

Date: Thursday, 2/14/2008 11:01:28 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	LUG BRACKET	
Job Number	37439		Part Number	D27353	
Estimate Number	10010		Drawing Number	D2735 REV C	
P.O. Number			Project Number	N/A	
This Issue	2/14/2008	S.O. No.	Drawing Revision	C	
Prsh Rev.	NC		Material		
First Issue	/ /	Type	Due Date	3/10/2008	Qty: 12 Um: Each
Previous Run	35434				
Written By	<i>JM 080214</i>				
Checked & Approved By					
Comment	Est Rev: C Removed from 9 Digit 05-10-25		JLM		
	Est. C 06.07.21 waterjet EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S125	1010-1025 sheet .125 <i>106140</i>
		Comment: Qty.: 0.1733 sf(s)/Unit Total : 2.0790 sf(s) 1010-1025 sheet .125 batch: <i>HB 8-2-21</i>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2735 Dwg Rev: <i>C</i> <i>HB 8-2-21</i> Prog Rev: <i>C</i>
		2-Deburr if necessary <i>HB 8-2-21</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>HB 8-2-21</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK <i>Jan 02-25</i> <i>(IS)</i> <i>is wanted.</i>
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204 <i>SB 08/03/12</i>
		2-Deburr if required.

W/I/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 11:01:28 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 37439

Part Number: D27353

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



08/03/12 (15)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Steve P08/3/12 (10)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(15)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/14

Job Completion



2008/3/13 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37439
Description: Lug Bracket	Part Number:	D2735-3
Inspection Dwg: D2735 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>FB</u>	Audited by:	<u>/</u>	Prototype Approval:	N/A
Date:	8-2-21	Date:	<u>080225</u>	Date:	N/A

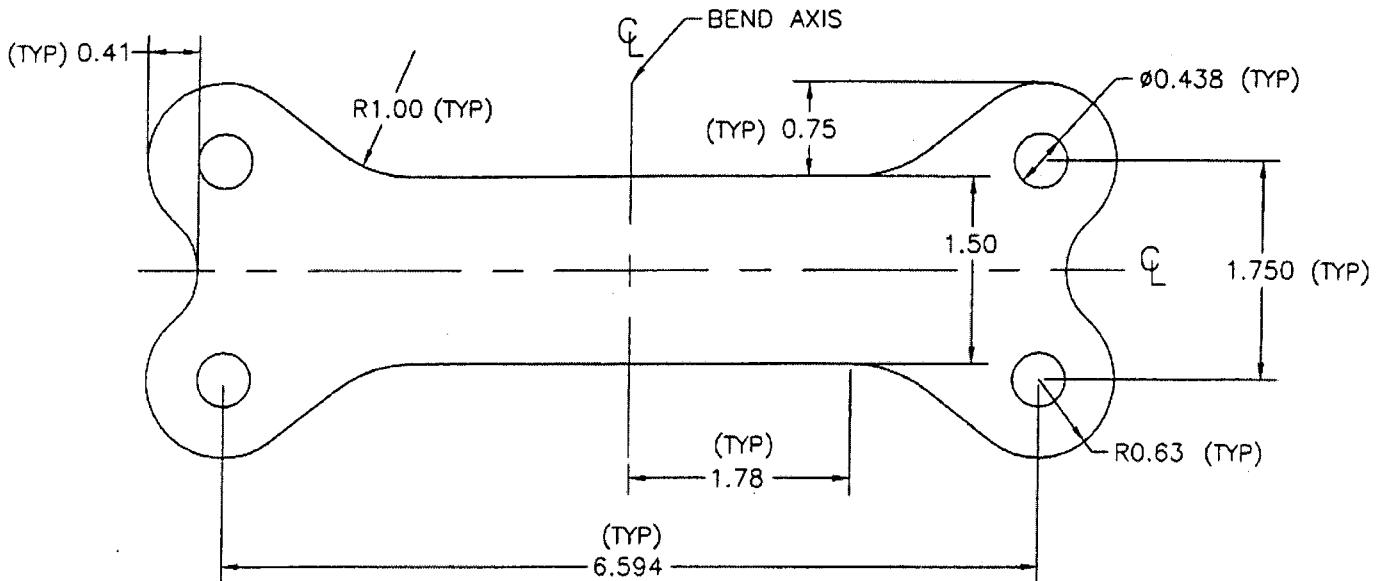
Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART

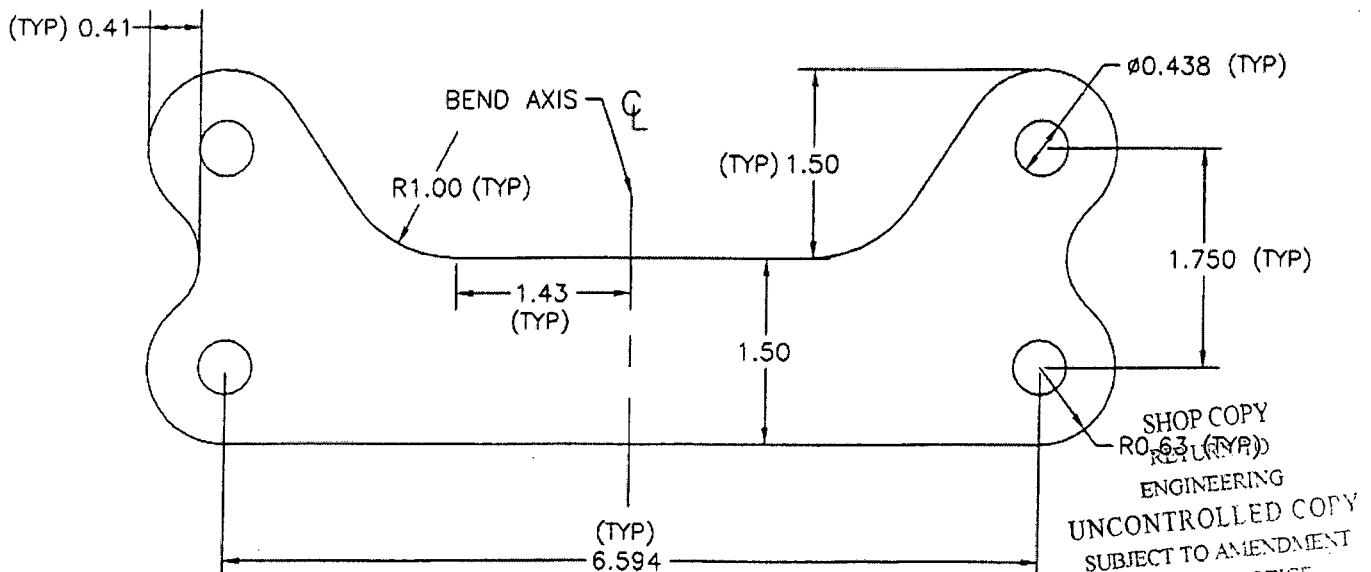


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2735 REV. C SHEET 1 OF 2
DATE 98.12.14		TITLE LUG BRACKET SCALF. 2.3

RELEASED
98.12.14 DS



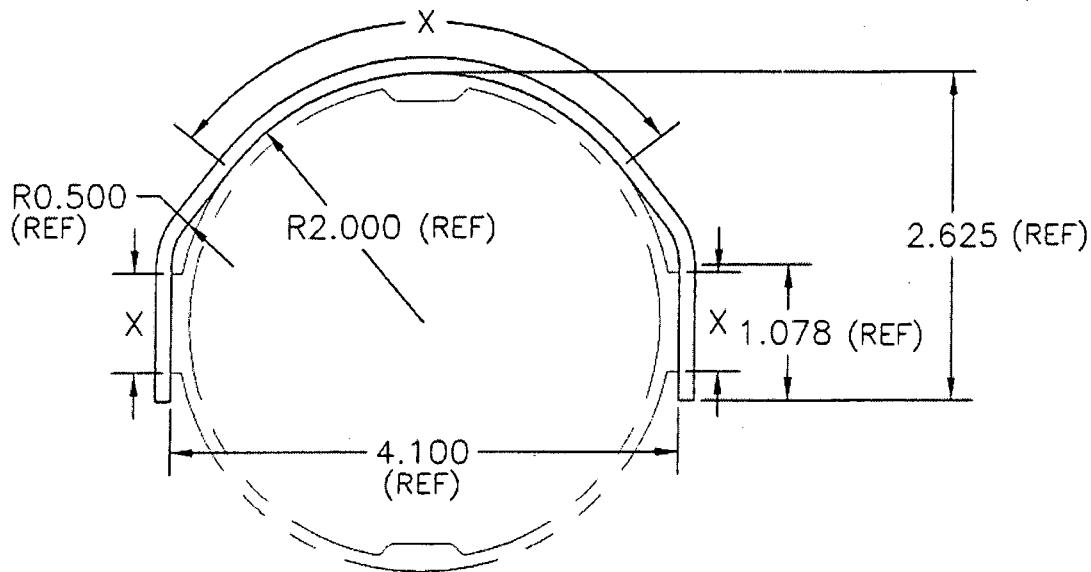
D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (C)



D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (C)

DART

DESIGN <i>SP</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED
98.12.14 DSD2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL

0.125 THICK (11 GAUGE)

MIN. ULTIMATE TENSILE STRENGTH = 42 ksi

MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *37439*